

extending the surface 53 (see FIG. 6). The clearance surfaces 51 and 61 should not be in engagement with each other during the machining operation, and therefore a gap P is always present between them (see FIG. 6). The gap P is in the range of 0.1–1.0 mm. The support surface 16 will be pressed by the feed force against the front surface 24 during the machining operation, which means that the elastic deflection of the projection 60 tends to decrease somewhat, which however is counteracted because the projection 60 will be bent radially inwardly due to pressure on the front surface 24 from the feed force.

The invention is useable also for milling cutters. The drill tip is preferably coated with layers of, for example,  $\text{Al}_2\text{O}_3$ , TiN and/or TiCN. In certain cases, it can be well-founded to apply super hard material such as CBN or PCD on the cutting edges. Alternatively ceramic material can be used at injection molding of the drill tips.

Although the present invention has been described in connection with a preferred embodiment thereof, it will be appreciated by those skilled in the art that additions, modifications, substitutions and deletions not specifically described may be made without departing from the spirit and scope of the invention as defined by the appended claims.

What is claimed is:

1. A rotary metal-cutting tool comprising, in combination, a tool body and a cutting portion attached to the tool body; the tool body including: a shank portion defining a longitudinal center axis, a front surface, and rear chip flutes formed in an external side surface of the shank for guiding chips rearwardly during a cutting operation; the cutting portion including: a rear support surface abutting the front surface, a front cutting surface, and front chip flutes formed in a side surface of the cutting portion and intersecting the cutting face to form cutting edges therewith; the tool body and cutting portion being interconnected by a dovetail-shaped bayonet coupling formed by projections disposed on one of the tool body and cutting portion, and recesses formed in the other of the tool body and cutting portion, the projections being circumferentially offset with respect to the flutes and extending generally longitudinally; the recesses extending circumferentially from respective flutes; the flutes sized to longitudinally receive respective projections during longitudinal insertion or removal of the cutting portion relative to the tool body; the cutting portion being rotatable about the center axis relative to the tool body to transfer the projections from the respective flutes into the recesses while bringing the front and rear flutes into mutual alignment.
2. The tool according to claim 1 wherein the recesses are formed in the cutting portion; and the projections are formed in the tool body.
3. The tool according to claim 1 wherein the recesses are formed in the outer surface of the cutting portion; the cutting portion being rotatable relative to the tool body by an angle less than 360 degrees.
4. The tool according to claim 3 wherein the angle is less than 60 degrees.
5. The tool according to claim 1 wherein each of the projections includes a first surface inclined obliquely relative to the center axis, the first surface facing generally radially inwardly and longitudinally rearwardly; each of the recesses including a second surface inclined obliquely relative to the center axis, the second surface facing generally radially outwardly and longitudinally forwardly and oppos-

6. The tool according to claim 5 wherein a material from which the tool body is formed has a lower Young's modulus than a material from which the cutting portion is formed, to enable the projections to bend elastically in a radial direction during relative rotation between the cutting portion and tool body.

8. The tool according to claim 6 wherein the outer surface of the cutting portion defines a pair of lands extending circumferentially by equal distances between the front flutes, each of the recesses extending circumferentially for a distance of about one-half of the circumferential distance of a respective land, each of the projections extending circumferentially a distance substantially equal to that of a respective recess.

35 **10.** The tool according to claim 1 wherein each of the projections includes a forwardly facing end surface, and the recess includes a forwardly facing end surface, and the recess includes a rearwardly facing end surface spaced from the forwardly facing end surface by a gap.

12. The cutting portion according to claim 11 wherein the coupling means comprises a recess extending circumferentially less than 60 degrees.

a drill body having a longitudinal axis and first and second opposed ends, one of said opposed ends comprising a centrally disposed dovetail-shaped recess, and at least two circumferentially spaced projections, each of said projections having a stop surface;

14. A method of attaching a drilling head to a drill body, said drill body having a longitudinal axis and first and second opposed ends, one of said opposed ends comprising a centrally disposed dovetail-shaped recess, and at least two circumferentially spaced projections, each of said projections having a stop surface; said drilling head having first

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projections, and the other of the tool body and cutting portion including circumferential recesses, each recess communicating with a respective flute and extending less than 180 degrees; the method comprising the steps of:

- 5     A) converging the cutting portion and tool body longitudinally toward one another to bring the projections into respective ones of the flutes that communicate with the circumferential recesses; and
- 10    B) effecting relative rotation between the tool body and cutting portion to cause the projections to enter respective ones of the recesses to bring the front flutes into alignment with the rear flutes, and to bring a stop surface of each projection into longitudinally opposing relationship with a stop surface of a respective recess
- 15    for defining a dovetail-shaped bayonet connection preventing longitudinal displacement of the cutting portion relative to the tool body.

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